DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-019559
Date Inspected: 13-Nov-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 1900
OSM Departure Time: 700
Location: Shanghai, China

CWI Name:	See below	**CWI Present:**	☑ Yes ☐ No
Inspected CWI report:	☑ Yes ☐ No ☐ N/A	**Rod Oven in Use:**	☑ Yes ☐ No ☐ N/A
Electrode to specification:	☑ Yes ☐ No ☐ N/A	**Weld Procedures Followed:**	☑ Yes ☐ No ☐ N/A
Qualified Welders:	☐ Yes ☑ No ☐ N/A	**Verified Joint Fit-up:**	☐ Yes ☑ No ☐ N/A
Approved Drawings:	☑ Yes ☐ No ☐ N/A	**Approved WPS:**	☑ Yes ☐ No ☐ N/A
		Delayed / Cancelled:	☐ Yes ☑ No ☐ N/A

Bridge No: 34-0006
Component: OBG

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 10
This QA Inspector observed the following work in progress for Bay 10.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Li Jun, CWI Zhang Zhong.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA Inspector.

Component; Bike Path
PCMK: BK004A6-025
Weld No.112,115,118,121,122,125,128,131
Welders: 040302, 500363
WPS-B-T-2232-TC-U4c-F

This QA Inspector observed the following work in progress for Bay 10.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Li Jun, CWI Xhang Zhong.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS). Listed below are the locations that were identified by this QA Inspector.

Component; Bike Path, fit up
PCMK: BK004A1
Weld No. 030
Tack Welder: 057242
WPS-B-T-2113

Component; Bike Path,
PCMK: BK004A1
Weld No. 027
Tack Welder: 048777
WPS-B-T-2113

Heat Straightening
Heat straightening of PCMK, GGL-MQ-1958-001~012 under approved Heat Straightening procedure, HSR1(B)-9747. The in process temperature was observed as 230°C. The ZPMC QC was identified as Li Jun. The approved HSR procedure stated that a maximum temperature of 650°C with 1~3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 5mm.

This QA Inspector performed MT on approximately 15% of the areas previously tested and accepted by ZPMC Quality Control personnel. The items observed by this Inspector, appears to comply with AWS D1.5 MT requirements. The members are identified as Bike Path BK004A6-001 weld numbers 68,74,94,112, BK004A7-001 weld numbers 9~12, 21~24,33~36,45~4857~60,69~72,81~84,93~96,105~108,117~120, and BK008A3-001 weld numbers 12,13,14,27,28,29,38,47,48,53,54,55,

Bay 11
Heat Straightening
Heat straightening of PCMK, SD1-BRSA5-2-6 A/B under approved Heat Straightening procedure, HSR1(T)-11557. The in process temperature was observed as 230°C. The ZPMC QC was identified as Li Jun. The approved HSR procedure stated that a maximum temperature of 650°C with 1~3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 3mm.

Heat Straightening
Heat straightening of PCMK, ND1-BRSA5-2-6 A/B under approved Heat Straightening procedure, HSR1(T)-11557. The in process temperature was observed as 230°C. The ZPMC QC was identified as Li Jun. The approved HSR procedure stated that a maximum temperature of 650°C with 1~3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 8mm.

Bay 16
This QA Inspector observed the following work in progress for Bay 16.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Li Jun, CWI Zhang Zhong.

WELDING INSPECTION REPORT

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Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS). Listed below are the locations that were identified by this QA Inspector.

Component; OBG Steel Barrier
PCMK: W5-SB1-066
Weld No.075~078,082~087
Welder: 206296
WPS-B-T-2133

Component; OBG Steel Barrier
PCMK: W5-SB1-063
Weld No. 075~078,082~087
Welder: 220314
WPS-B-T-2133

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:
No significant conversations
Comments
This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt,Kelly	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer